

Work Order ID 1300987

130098

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February-23-15 11:25:30 AM

Item ID: D4155-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bar

Start Date: 2/23/15 Start Qty: 12.00

12

Cust Item ID:

Required Date: 3/03/15 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: MLJDate: 1502-26

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4155

E

100

0.00

100

Cold Saw

Memo

0.00

Hyd Mech

Cut blanks at 92.00"

(EXTRA MATERIAL WILL BE CUT ON ASSEMBLY D4154-041)

12

0

DAS
20
9-89

1503-17

110

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Mill as per folio FB048 & dwg D4155,

FOLIO REV: AADWG REV: E

2-Deburr as required

12

0

DAS
20
9-89

1503-18

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Stop ***NR2***

[illegible]

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Item ID: D4155-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bar
 Start Date: 2/23/15 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 3/03/15 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

MCS 1503-19
MF
15-3-19

Picklist Print

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Work Order ID: 130098

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Parent Item: D4155-1

D4155-1

Parent Item Name: Bar

Start Date: 2/23/15

Required Date: 3/03/15

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 10.08.03 new issue DD verf:EC
11.04.14 as per dwg revB DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304B0.250x0.500

Purchased

No

100

f

87.9160

7.6333

97

DAS

M304B0 250x0 500

**

93.000'

20
9-89

15-03-17

304 BAR .250 x .500

Location

Loc Qty

Loc Code

MAT009

87.916

m129366

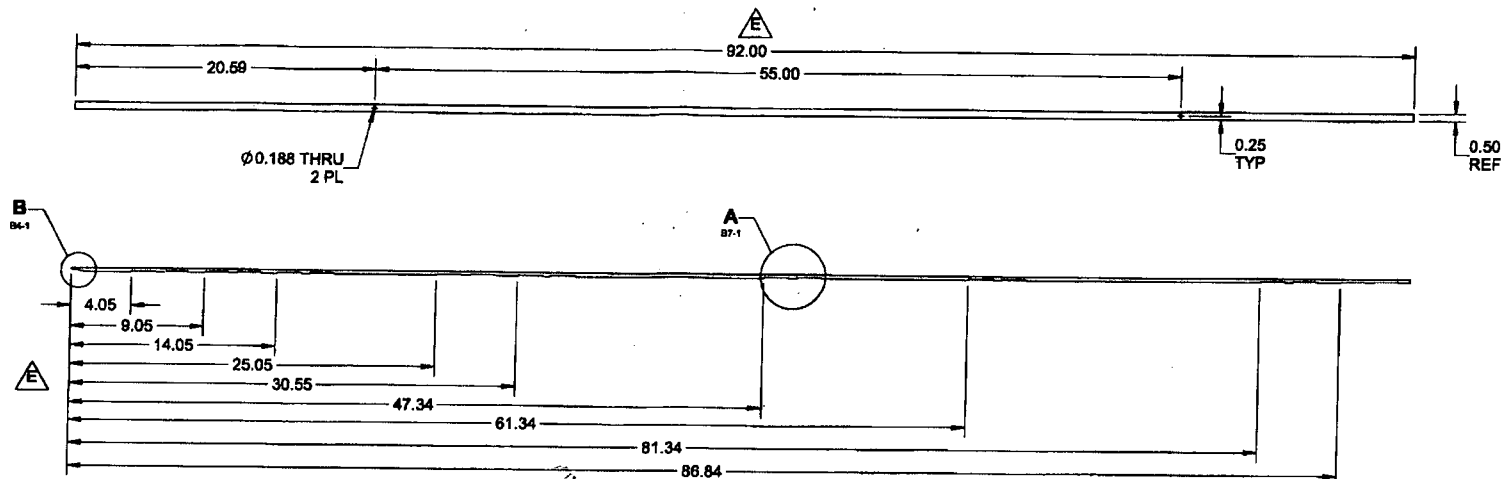
32.316

m131205

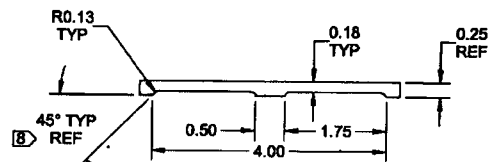
55.6

131748

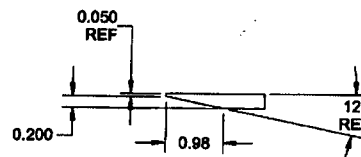
93.000'



D4155-1 BAR



DETAIL A
SCALE 2X



DETAIL B
SCALE 2X

NOTES:

- 1) MATERIAL : AISI 304/316 STAINLESS STEEL BAR, 0.25 THICK X 0.50 WIDE PER ASTM A276 OR ASTM A240
REF. DART SPEC. M304B0.250X0.500
- 2) FINISH : NONE
- 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS : INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
- 6) IDENTIFICATION : NONE
- 7) WEIGHT : 2.98 lbs
- 8) ANGLE TO BE DETERMINED BY AVAILABLE TOOLING.

E	DIMENSION DATUM ON OPPOSITE END OF PART; 92.00 WAS 91.59 REF CIR12-10	SFM	13.02.20
D	REDESIGNED WITH SHORTER CUTOFFS. NOTE 6 ADDED. (PAR 12-213); 0.18 WAS 0.13	AJS	12.08.07
C	REMOVED TOOLING HOLE; ADD CUT OUT PROFILE (ZN C8-1 & C7-1); 2 DEC TOLERANCE (D1-1, D2-1)	RF	12.02.21
B	CHANGED MANUFACTURING PROCESS; MATERIAL WAS 0.50 THICK (A8-1); 0.25 REF WAS 0.20 (B8-1); 0.13 WAS 0.08 (B7-1)	MB	11.04.05
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D4155 TITLE BAR SCALE NTS	
DRAWN	SRM		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		REV. E SHEET 1 OF 1 DATE 13.02.20	
DATE			

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RELEASED
2013-08-13

130098 MJS
15-02-26